

Date: Tuesday, 8/21/2007 3:42:51 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE SPACER
Job Number : 34173	
Estimate Number : 11062	
P.O. Number : N/A	Part Number : D2934
This Issue : 8/21/2007 S.O. No. N/A	Drawing Number : D2934 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : B
Previous Run : 33235	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 8/28/2007
Checked & Approved By : <u>[Signature]</u>	Qty: 60 Um: Each
Comment : Est A 00-06-06 New Issue EC Est Rev:B Now 6061-T6 06-06-23 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S080	6061-T6 .080 Sheet
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Comment: Qty.: 0.0334 sf(s)/Unit Total : 2.0034 sf(s)

Material: 6061-T6 0.080" Thick

Batch M104392 IB 07-08-23

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2934

Dwg Rev: B IB 07-08-23

Prog Rev: B

2-Deburr if necessary M107/08/27 (x61)

(61)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 07-08-23



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/09/28 (461) Count

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M1 07-08-29

P10 (61)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/08/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/08/29	#5.0	Mat. has excess mark mat. Material, has mild oxidation on Rt.	<i>[Signature]</i> QSI/12	Buff out marks and Re alod in AS per QSI 005 4.4	<i>[Signature]</i> 07-08-29 (18)	<i>[Signature]</i> 140829	<i>[Signature]</i> QSI/12	<i>[Signature]</i>

NOTE: Date & initial all entries

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Drawing Name: SADDLE SPACER

Job Number: 34173

Part Number: D2934

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/8/29 61x SP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/8/29 61x SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

61x SP
7/21/08/30

Job Completion



7/21/08/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

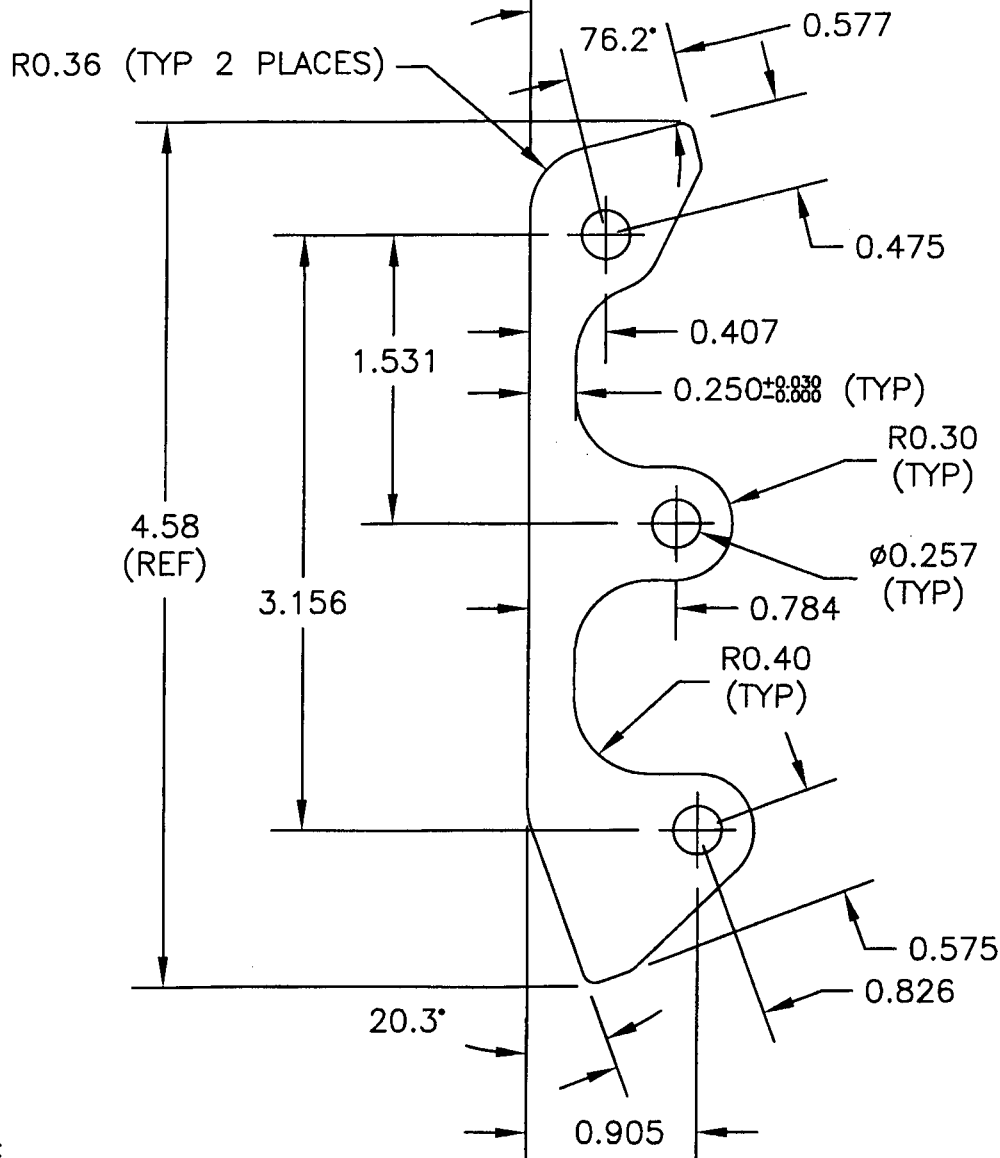
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN 74	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)

2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) BREAK ALL SHARP EDGES 0.010 TO 0.020

5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34173

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